

Thursday 3/30/2006 10:05:37 AM
 Kim Johnston

Process Sheet

spit

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26443 -1
 Estimate Number : 10495
 P.O. Number : N/A
 Date Issued : 3/30/2006 S.O. No. : N/A
 Unit Rev : NC
 Unit Issue : N/A Type : MACHINED PARTS
 Previous Plan : N/A
 Written By : SEE ABOVE WORK ORDER
 Checked & Approved By : JF 06.03.30
 Comment :
 Drawing Name : LITTER TIE DOWN ASSY (LOCKING)
 Part Number : D2360
 Drawing Number : D2360 REV. C1
 Project Number : N/A
 Drawing Revision : C1
 Material : N/A
 Due Date : 4/6/2006 Qty: 5 U/m: Each

Additional Product

Job Number



Seq. #:

Machine Or Operation:

Description :

1.0

D6201

T Extrusion 4X4X3/8



Comment: Qty.: 1.1067 f(s)/Unit Total: 5.5335 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion)

Batch: B11772

JNL 06/04/02

5

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: 12.65" Long

JNL 06/04/02

5

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2341 and Dwg D2341

JNL 06/04/02

5

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JNL 06/04/02

5

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JNL 06.04.03

5

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Deburr and Tumble

J.G/EN 06/04/03

5

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26443

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BC

06-04-04

5

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m

06-04-04

5

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-04-04

5

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DC

06/04/05

5

11.0

D2002015

Knob



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Knob

B 16 1770

12.0

D2345

Lock Channel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Lock Channel

B 18545

13.0

D2366

Lock Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Inventory

B 19488

14.0

D2367

Handle Knob



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Inventory

B 18443

B 26592

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26443

Part Number: D2360

Job Number:



Seq. #: Machine Or Operation: Description :

15.0 D2372 Quick Release

Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Quick ReleaseQ 19 289
Q 19 324

16.0 D2373 Spring

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Spring

B 19 503

17.0 D2444 Pip Pin Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pip Pin Assembly

D 25324

18.0 AN526C1032R16 Screw

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Screw

M 4023

19.0 AN960JD10 Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Washer

M 19 521

20.0 AN960JD10L Washer

Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)
Washer

H 18235

21.0 MS20470AD34 Rivet,Universal Head

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Rivet,Universal Head

M 15341

22.0 MS21042L3 Nut

Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)
Nut

M 18917

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26443

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
Screw

M13719 ✓

24.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Screw

M15432 ✓

25.0

NAS679A3W

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
Nut

M19487

SR 06/04/06 (2)

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D2360

SR 06/04/06 (2)

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SR 06/04/06 (2)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST171

SR 06/04/06 (2)

29.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SR 06/04/06 (2)

Job Completion:



M 06/04/07



DESIGN <i>B.W.</i>	DRAWN BY <i>B.W.</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>B.W.</i>	DRAWING NO. D2360	REV. C SHEET 1 OF 2
DATE 97.08.27		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING)	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
C1	02.09.24	D2002-015 WAS D2576	

RELEASED
97 08 27 D.W.

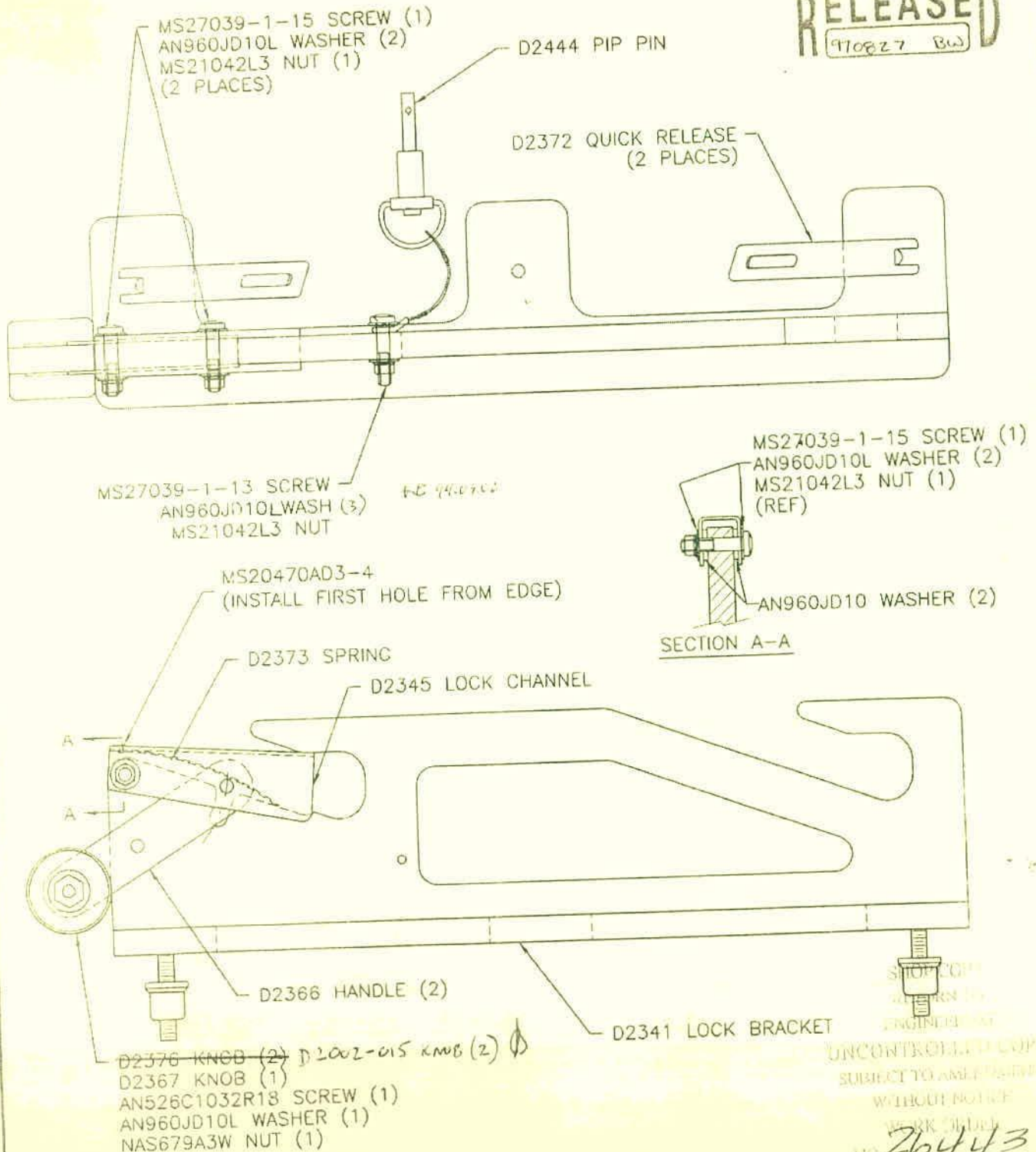
D2360	Part No.	Description
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2376	KNOB (DELRIN) D2002-015 #1
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
3	AN960JD10	WASHER
5	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

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SUBJECT TO APPROVAL
WITHOUT NOTICE
WIRE CORD
NO. 26443



DESIGN <i>BW</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>LE</i>	APPROVED <i>MB</i>	DRAWING NO. D2360	REV. C SHEET 2 OF 2
DATE 97.08.27		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING)	

RELEASED
970827 BW

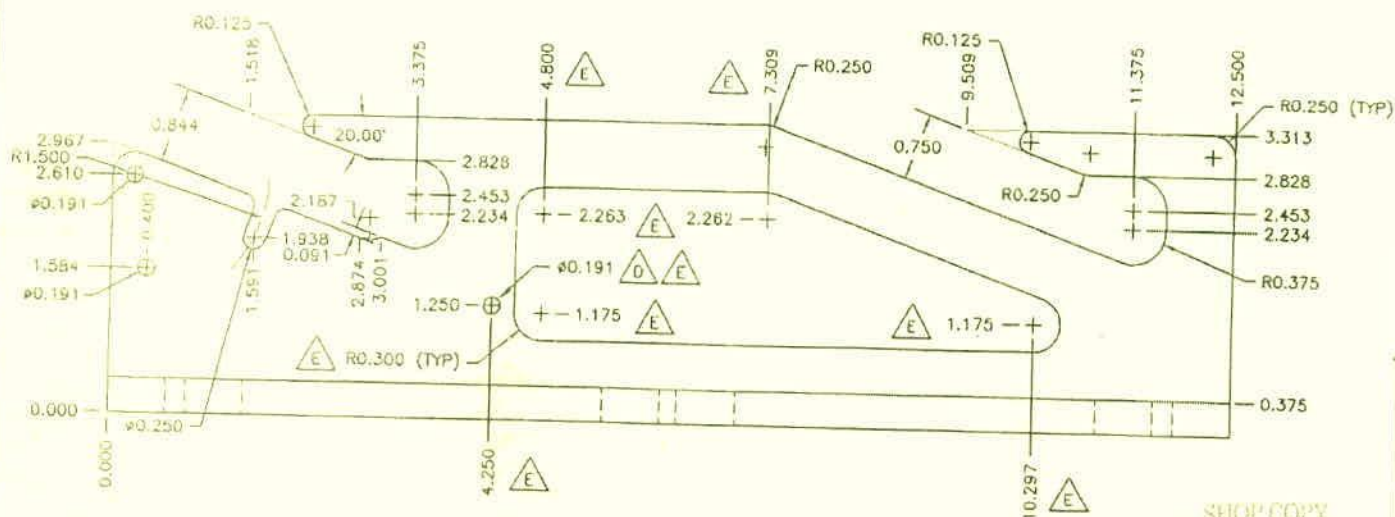
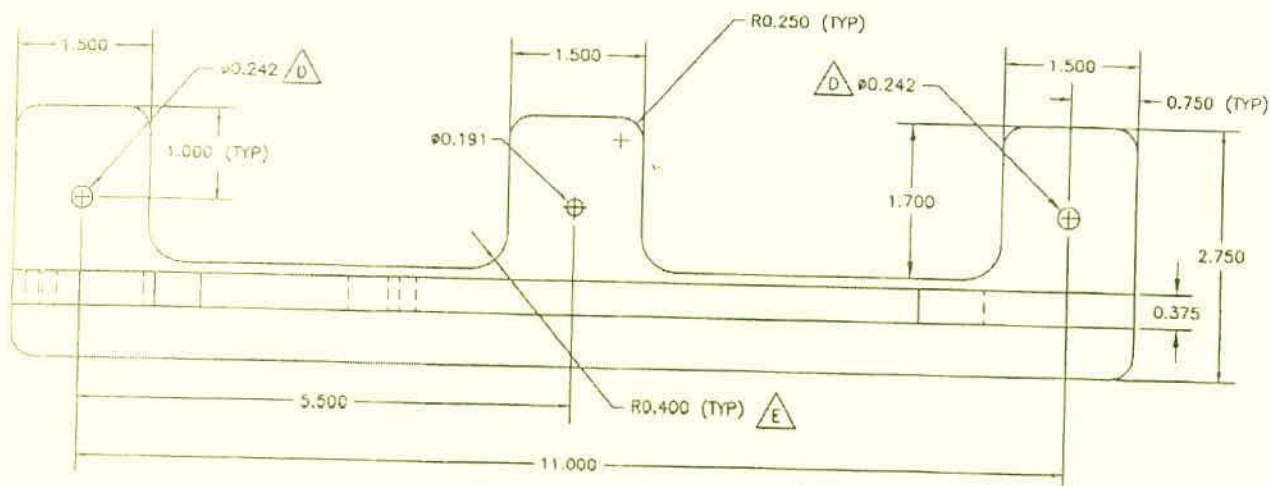


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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26443



RELEASED
971003 RE
TWR 480

DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MB	APPROVED BW	DRAWING NO. D2341	REV. E SHEET 1 OF 1
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	



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EPOCH-ENRICH

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ON WITHOUT NOTICE

WORK FIELD

76443

MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION
FINISH: ANODIZE

FINISH: ANODIZE

WORLD LTD

W.O. Number

26443

Part Name: *Base Bracket*

Part Number

D2366

Rev: *1.0*

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☐ Prototype

Quantity	Reference	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	1.000	1.546	✓			
1.000	1.000	1.242	✓			
1.000	1.000	1.000	✓			
1.000	1.000	0.971	✓			
1.000	1.000	0.842	✓			
1.000	1.000	1.242	✓			
1.000	1.000	1.673	✓			
1.000	1.000	1.546	✓			
1.000	1.000	1.000	✓			
1.000	1.000	1.752	✓			
1.000	1.000	1.371	✓			
1.000	1.000	1.000	✓			
1.000	1.000	1.700	✓			
1.000	1.000	1.777	✓			
1.000	1.000	1.000	✓			
1.000	1.000	1.579	✓			
1.000	1.000	1.377	✓			
1.000	1.000	2.440	✓			
1.000	1.000	1.844	✓			
1.000	1.000	1.521	✓			
1.000	1.000	1.823	✓			
1.000	1.000	1.293	✓			
1.000	1.000	4.249	✓			

Audited by: *ML*

Prototype Approval:

Date:

06/04/03

Date:

Revised by

Approved

KJ (S)

Project No.	26493
Drawn By	D. J. J. J.
Check By	D. J. J. J.
Page 1 of 1	

SECTION CHECK

☒ First Revision ☐ Prototype

Actual Dimension	Accept	Reject	Location of Defect	Comments
0.11	-	-		
0.12	-	-		
0.13	-	-		
0.14	-	-		
0.15	-	-		
0.16	-	-		
0.17	-	-		
0.18	-	-		
0.19	-	-		
0.20	-	-		
0.21	-	-		
0.22	-	-		
0.23	-	-		
0.24	-	-		
0.25	-	-		
0.26	-	-		
0.27	-	-		
0.28	-	-		
0.29	-	-		
0.30	-	-		
0.31	-	-		
0.32	-	-		
0.33	-	-		
0.34	-	-		
0.35	-	-		
0.36	-	-		
0.37	-	-		
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0.39	-	-		
0.40	-	-		
0.41	-	-		
0.42	-	-		
0.43	-	-		
0.44	-	-		
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0.46	-	-		
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0.95	-	-		
0.96	-	-		
0.97	-	-		
0.98	-	-		
0.99	-	-		
1.00	-	-		

Reviewed By	Prototype Approved
Date	06/04/03
Reviewed By	Approved

